DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-003705

Address: 333 Burma Road **Date Inspected:** 19-Aug-2008

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1500 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Zhang Huang/Li Yang No **Inspected CWI report:** Yes **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** skin plates and stiffeners

Summary of Items Observed:

Tower Shop - Bay 1

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed ZPMC personnel performing the following: SAW of NSD1-SA10A/K-16A skin plate butt weld under the direction of ZPMC CWI Zhang Huang and ABF QC Xiao Jun Peng; FCAW-G automatic with gantry of stiffener to SSD1- skin E; heat straightening of skin plates and grinding on same. Approximately 50 workers were present in this shop including ZPMC CWI and ABF QC noted above.

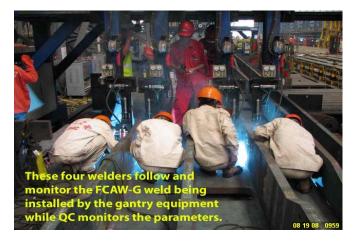
Tower Shop – Bay 2

QA Inspector randomly observed ZPMC personnel performing performing the following: manual FCAW-G of stiffener to skin plate welds on ESD1- skin A which was tilted up to create a flat position for this welding; FCAW and SAW of stiffener butt welds; FCAW-G automatic with gantry and FCAW-G manual of stiffener to ESD1skin E welds. ZPMC CWI Li Yang and ABF QC Xing Xiao Guang were present as well as approximately 40 ZPMC workers.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer